

Date: Friday, 9/29/2006 10:42:35 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28785A
Estimate Number : 10023
P.O. Number : N/A
This Issue : 9/29/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 28784A
Written By :
Checked & Approved By :
Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC

Drawing Name : SKID TUBE ASSEMBLY
Part Number : D205634041
Drawing Number : D2580 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 10/25/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

KS 06.10.11

2.0 D25001190 Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

Qty Part Number Description Batch

1 D2500-1-190 Skid Tube Extrusion

Batch

B25858

DP 6-10-26

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2596 205 Web

Batch

B28652

Pm 06-11-01

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

DP 6-10-26
M.R 06/10/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:42:35 AM
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Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 28785A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

Pm' 06-11-01 (1)

6-Countersink holes as per Dwg D2580 without cutting fluid

Pm' 06-11-01 (1)

7-Deburr and blow out all chips from inside of tube

Pm' 06-11-01 (1)

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	<i>m102107</i>	
Sikaflex expire date: <i>07-02-01</i>			
Start Time: <i>2:30pm</i>		Date: <i>06-11-01</i>	
Fin Time: <i>11:45am</i>		Date: <i>06-11-06</i>	

Pm' 06-11-01 (1)

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

> DP 06-11-06

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

M.R 06/11/10 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06/11/10

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>23060 BE 06/11/10</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 28785A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	327921

06-11-10

BE 06-10-10

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 06-11-10

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M101655

BE 06-11-10

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill.

A/R

Aluminum Rod

M101655

BE 06-11-10

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

pm 06-11-13

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

pm 06-11-13

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

pm 06-11-13

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

pm 06-11-13

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

pm 06-11-13

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

11/06/11/13

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

am

06/11/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 28785A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 16 (D)

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	26350

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	28013

16.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	241878

17.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	18990

18.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	100233

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 28785A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	18369

20.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: 26364

21.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-ring

Batch: 27168

22.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 26351

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 15205

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 100233

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:42:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 28785A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: 0207

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 0207

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

Diagram of a propeller hub with the following labels and instructions:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH
- GRIND FLUSH STEP

Technical drawing showing a cross-section of a cap installation. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241
- AN3-4A BOLT (1)
- AN960J10L WASHER (1) (2 PLACES)
- D2575 CAP
- 0.40

D2579 SPACER

WEB (REF)

-130 (REF)
4 PLACES

AFTER PERFORM

1. CHA
2. INS
3. WEL
4. C'B

0.40
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28785A

37.50
DISTANCE TO AFT END
OF D2596 WEB

38.0

190.0
(D2500-1)

34.188

26.000

17.375

8.750

1.750

1.750

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

#0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

Figure 1: Typical cross-section of a 12' wide concrete curb and gutter. The diagram shows a cross-section of a road with a 12-foot wide concrete curb and gutter. Key dimensions include a 1.4-inch curb height, a 1.0-inch distance between the hole and the tangent point, a 13.4-inch distance from the hole to the gutter edge, a 20.0-inch distance from the hole to the gutter edge, a 32.0-inch distance from the hole to the gutter edge, and a 11-inch gutter depth. A 4-inch diameter hole is shown in the curb.

0.5

1.5

1.5

D

P P P P P P P P

REFER TO DETAIL C

D2577-3

8

D2577-5

D2577-1

AN3-4A BOLT (1)
AN96QJ10L WASHER (1)
(44 PLACES)

DESIGN [Signature]

DRAWN BY [Signature]

RABT

RELEASED
98/09/17 DS

DESIGN <i>DAF</i>	DRAWN BY <i>CP</i>	DART DART AEROSPACE LTD. HINCHESBURY, ONTARIO, CANADA
CHECKED <i>DAF</i>	APPROVED <i>JS</i>	
DRAWING NO. D2580		REV. C SHEET 2 OF 2
DATE 98.08.26	TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24	

NO. 72

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 205634045/B29153

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/08 Qualifier David Aural

Date: Friday, 9/29/2006 10:41:54 AM
 User: Kim Johnston

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Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 28785		
Estimate Number	: 10022		
P.O. Number	:	Part Number	: D205634011
This Issue	: 9/29/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 28784	Drawing Revision	: N/A
	Type : LANDING GEAR	Material	:
Written By	:	Due Date	: 10/25/2006
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

2.0	28785A	SKID TUBE ASSEMBLY
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**Comment:** Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B _____

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit _____

1 D205-634-041 Skidtube Assembly(ref) _____

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------

**Comment:** INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES						
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Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 28785

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ce Dec-17

W/O:		WORK ORDER CHANGES						
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